Tuesday, Novem	ber 23, 2010	9:25:22 AM			[]					Page
Item ID: Revision ID:	D3500-1			Accept			iiii s	etup Star		
	Saddle 11/22/2010 11/30/2010	Start Qty: 12.00 Req'd Qty: 12.00			Cust Item ID: Customer:			Sto		
Approvals:	Process Pla	nn:	Date: <u>/ O-//-</u> Date:	Tooling: SPC (Y/N):	Date:		R	tun Star Sto	i ibbliffi b	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr			. A .	•				
HAAS 1	I machine #1	per Folio F. No 2 per Fo	atch No. <u>(3995</u> Dou A641 and inspect per a	ttached Dimension Sheets Diper attached Dimension She			12	\$		
QC Quality Control		QC2- Inspect parts off r	nachine FAI/FAIB	0.00 0.00	2 11/01/06 A 11/01/10		12	<u>Ø</u>		
120 QC Quality Control		QC8- Inspect parts - sec	cond check	0.00	11/13		12	· de		

Dart Aerospa	ace Ltd
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	-									4
W/O:			WC	ORK ORDER CHAN	IGES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					+		- · · · · · · · · · · · · · · · · · · ·			
					i i					
Part No):	PAR #:	Fault Cate	gory:	NCR: Y	es No	DQ.	A:	Date: _	
Resolution: Disposition:										
NCR:		,	WORK ORD	ER NON-CONFORM	MANCE (N	CR)				
DATE	STEP	Description of NC	Initial		ection B	gn &		cation	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng		ate	Secti	ion C	Chief Eng	QC Inspector
				• •						

Work Order ID 63995

Tuesday, November 23, 2010 9:25:22 AM



Page 2

Item ID:

D3500-1

Accept

Setup Start



Revision In:

Start Date:

Saddle Item Name:

Required Date: 11/30/2010

11/22/2010

Start Oty: 12.00

Req'd Qty: 12.00

Chemical Conversion Coat per OSI005 4.1



Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Operation

Description

Date:

Tooling: SPC (Y/N): Date:

Date:

Run

Start Stop

Stop



Sequence ID/ Work Center ID

130

HandFinish

Memo

Run Hours

0.00

0.00

0.00

Set Up/

Tool ID

Tool # Plan Code

Accept Oty

Reject Oty

Reject Number Stamp

Insp.

Hand Finishing

140

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum

M [1595],

□OVEN, TEMPERATURE:

12 BQ 11-01-14

150

Quality Control

QC3- Inspect Part Finish

0.00

0.00

12 & All 16/00/19

Memo

Dart Aerospace

W/O:			WO	RK ORDER CHANGE	S				* . 9
DATE	STEP	PRC	OCEDURE CHAN	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	,								
Part No: PAR #:									
Resolution:								Date:	
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		n B	Verific	ation	Approval	Approval	
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Section C		Chief Eng	QC Inspector
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<u> </u>						•			
!									

Work Order ID 63995

Tuesday, November 23, 2010 9:25:22 AM



Page 3

Item ID:

D3500-1

Accept



Setup Start

Stop



Revision ID.

Start Date:

Item Name:

Required Date: 11/30/2010

Saddle

11/22/2010

Start Qty: 12.00

Req'd Qty: 12.00



Date: _____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:

Tooling:

Date:

Date:

Start

Stop

Sequence ID/ Work Center ID

160

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: 424

Memo

Memo

Set Up/ Run Hours

0.00

0.00

SPC (Y/N):

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Run

Reject Insp. Number Stamp

170

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	ES				• ,		
DATE	STEP	PRO	CEDURE CHA	ANGE	Ву	By Date Qty Appro					
						•					
							•				
Part No	:	PAR #:			_ NCR: Yes	No DQ	A:	় Date:	· · · · · · · · · · · · · · · · · · ·		
	R	esolution:	Disposition	on:	QA: N/C Closed: Date:						
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)					
DATE	STEP	Description of NC		ion B	Verifi	cation	Approval	Approval			
DATE	SIEP	Section A	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		tion C	Chief Eng	QC Inspector	
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	·										
	ļ								}		

Picklist Print

Tuesday, November 23, 2010 9:25:26 AM

Work Order ID: 63995

Parent Item:

D3500-1

Parent Ite Name: Saddle



Start Date: 1!/22/2010

Required Date: 11/30/2010

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013		Manufactured	No			100	Each	52,0000	1 	12	 -		

Saddle Billet

Location	Loc Oty	Loc Code	
MAT43	52		
59467	3	-	,
60713	8		
61300	1		
62010	40		

B64278 X12 and 11/01/06

Dart Aerospace Ltd	d
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W/O:			. V	ORK ORDER CHANG	GES					• •
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
·										
			·						•	
Part No	:	PAR #:	Fault Ca	tegory:	_ NCI	R: Yes	No DQ	A:	_ Date: _	
Resolution:			Disposit	ion:	QA	N/C CI	osed:		Date: _	
NCR:		100	WORK OR	DER NON-CONFORM	ANCE	(NCF	R)			
		Description of NC			tion B	·	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign 8 Date	k Sec	tion C	Chief Eng	QC Inspector
			·							
	4.									
				,		·				

DART AEROSPACE LTD	Work Order:	43995
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1

	·			Red	corded Actu	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
A	0.483	0.490	VIIN ML-7	.486	48%	.486	.486		
В	1.175	1.185	11	1.18/2	1.186	1.180	1.180		
С	3.145	3.155	1.0	3.150	3.150	3.50	3.150		
D	1.175	1.185	10.	1.180	1.180	1.180	1.180		
E	0.365	0.385	14 .	.345	-325	.375	375		
F	∩ 490	0.510	и	.495	,501	4910	-49/0		
Н									
.1	R1.575	R1.595	test indicate	1.594	1.595	1.587	1.586		
J	0.240	0.260	VUA ML7	~24 6	245	252	.252		
K	0.490	0.510	. ,	,497	.498	,500	.506		
Ĺ	3.590	3.650	, (3.610	3.1.2h	3.620	3.620		
М	0.315	0.322		.317	-317	317	-317		
N	0.256	0.262	11	259	.259	. 259	-259		<u> </u>
0	6.500	6.520	Vern CK-02	6.571	6.571	10.570	10.570		
Р	5.990	6.010	, 1	6.000	6.004	6.003	6.003		
Q	2.820	2.830	Vera HI-7	2.825	2.825	2.825	2.825		
R	2.495	2.505	cr	2.500	2,500	2.500	2500		
S	∠.245	2.255	11	2,850	2.250	2.250	2.25%		
Т	1.120	1.130	1 c	1.125	1-125	1.125	1.125		
U	0.540	0.560	А	.545	.552	,550	-550		
V.	0.793	0.803	10, 4	798	.798	.798	. 748		
W	R.240	R.260	Rel-ORDO REF	.250	-250	250	1250		
X	0.040	0.060	Red-gage REF Vern ML-7	.045	.060	-040	.055	1	
Y	0.100	0.120		.107	120	-117	.112		
							4		
AA	R1.125	R1.145	test indicator	1.131	1.140	1.130	1.132		
AB	R.490	R.510	ReligigREF Wern ML-7	500	.500	.500	.500		
AC	0.615	0.635	Vern HL7	.635	·635	.635	.635		
AD	0.240	0.260	Veon HIZ	.250	245	.255	.252		
AE	/ .810	1.830	11	1.823	1.820	1.820	1.820		
AF	0.240	0.260	1.0	.247	.257	.250	.250		
AG	0.140	0.160	11	.148	1.155	-/55	.1570		
AH	9.140	0.160	11	.158	.158	.160	-160		
ΑI	0.140	0.160	1,	.155	-155	160	160		
	Acce	pt/Reject	·						

		_			<u> </u>	
Measured by:	Onl		Audited by	C.	$\overline{\mathcal{I}}$	
Date:	11/01/07		Date:	11/	\overline{C}	//3

Rev	Date	Change	Revised by Approved
Α	06.09.26	New Issue	KJ/EC
В	08.10.07	Dimension H removed	KJ/DD
С	08.11.28	Dimension 'M' revised	KJ/EC ox

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANGES	S	•				
DATE	STEP	PRO	OCEDURE CHA	CEDURE CHANGE			Qty 🧃	Approval Chief Eng./ Prod Mgr	Approval QC Inspector	
									1	
						i				
		·								
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:		Date: _		
	R	esolution:	Dispositio	n:	QA: N/C Cld	A: N/C Closed: Date:				
NCR:		1		ER NON-CONFORMAN	ICE (NCR)				
DATE	STEP	Description of NC		Corrective Action Section		Verificat	ion	Approval	Approval	
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	С	Chief Eng	QC Inspector	
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				e .						
						1.1				

DART AEROSPACE LTD	Work Order:	43995
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1

				Re	corded Actu	ıal Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1/5	76	37	#8	Ву	Date
Α	0.483	0.490		.486	.486	.787	0.486		
В	1.175	1.185		1.180	1.180	1.180	1.180		
С	3.145	3.155		3.150	3.150	3,150	3.150		
D	1.175	1.185		1-180	1.180	1.180	1, 180		
E	0.365	0.385		.375	-375	-375	0.375	<u> </u>	
F	∩ 490	0.510		,497	.497	-487	0.499		
H									
	R1.575	R1.595		1.589	1.588	1.538	1.588		
J	0.240	0.260		.252	.253	.253	0.254		
K	0.490	0.510		. SOO	-500	. 425	0.500		
L	3.590	3.650		3.420	3,420	3620	3.420		
M	0.315	0.322		317	-317	-3/6	0.317	<u> </u>	
N	0.256	0.262		.259	.259	-258	0.259		
0	6.500	6.520		6.571	6.571	6.51	6.510		
Р	5.990	6.010	<u> </u>	6.004	Lo. DDY	6.004	6.003		
Q	2.820	2.830		2.825	2.825	2825	2.825		
R	2.495	2.505		2.500	2.500	3,200	2.500		
S	∠.245	2.255		2.250	2,250	2.250	2.250		
Τ	1.120	1.130		1.125	1.125	1125	1.125		
U	0.540	0.560		-557	-557	-552	0.552	 	
V	0.793	0.803		.798	798	1798	.498		
·W	R.240	R.260		. 250	250	1250	0.250		
Х	0.040	0.060		.055	.65%	2036	6.050		
Y	0.100	0.120		.115	.118	1.14	0.110		
				<u> </u>	1 1 = =		, 101		
AA	R1.125	R1.145		1./35	1./35	1.133	1.134		
AB ·	R.490	R.510		·50b	.500	. 200	0.500		
AC.	0.615	0.635		.635	-635	-835	0.635	 -	
AD	0.240	0.260		,257	,249	1 2 2 2	0.253		
AE	810	1.830		1.823	1.024	1. 822	1.822		
AF	0.240	0.260		-253	.252	:257	0.254	-	
AG	0.140	0.160		156	.157	1.5%	.157		
AH	0.140	0.160	·	158	.150	156	0.159	-	
ΑI	0.140	0.160		,/55	.154	.155	0.156	 	
								 	
	A = = =	-AID - i - c i						 	
<u></u>	ACCE	pt/Reject		L				<u></u>	

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Measured by:	Chil.	1	Audited by	8	7
Date:	11/01/07]	Date:	in	/(//3

Rev	Date	Change	Revised by	Approved
Α	06.09.26	New Issue	KJ/EC	
В	08.10.07	Dimension H removed	KJ/DD ,	
С	08.11.28	Dimension 'M' revised	KJ/EC	N

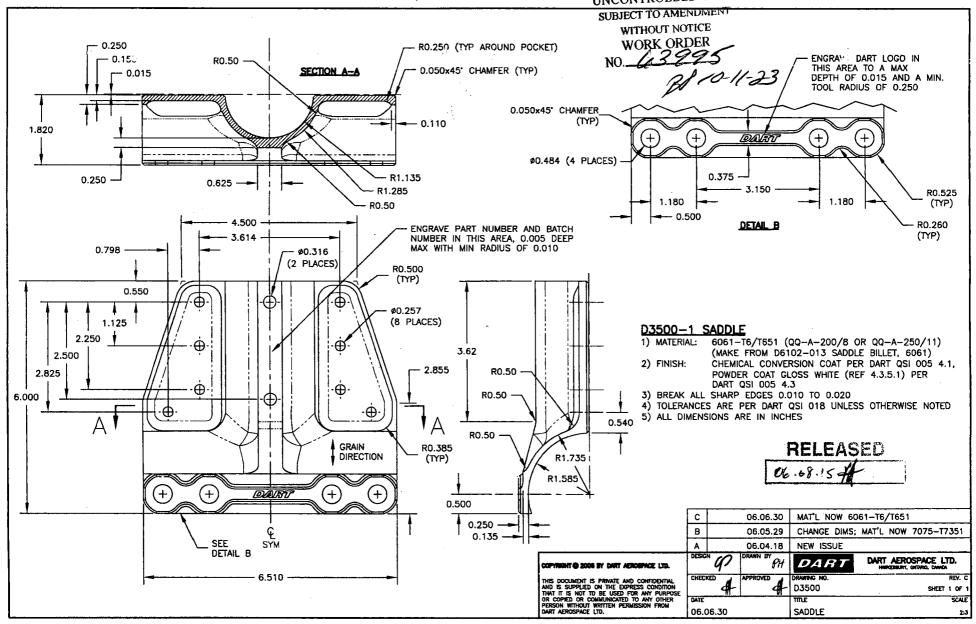
DART AEROSPACE LTD	Work Order:	43995	
Description: Saddle	Part Number:	D3500-1	
Inspection Dwg: D3500 Rev: C		Page 1 of 1	

Recorded Actual Dimensions					corded Acti	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	19	7 10	711	#12	Ву	Date
Α	0.483	0.490		0.486	0.486	0.486	0.486	Verg	6A-01
В	1.175	1.185		1.180	1,180	1.180	1, 180	£1	11
С	3.145	3.155		3.150	3.150	3.150	3.150	D	- 11
D	1.175	1.185		1.180	1.180	1,180	1.180	()	11
E	0.365	0.385		0.375	0.375	0.375	0.375	()	11
Ę	0.490	0.510		0.499	0.4199	0.499	0.499	11	11
Н					_				
ı	R1.575	R1.595		1.587	1,588	1.588	1,588	Dial	HAASZ
J	0.240	0.260		0.253	0.253	0.254	0.253	Vern	GA-01
K	0.490	0.510		0.500	0.500	0.500	0.500	(1	11
L	3.590	3.650		3.620	3.620	3-620	3.620	13	l+
M	0.315	0.322		0.317	0.317	0.317	0,317	11	<i>l</i> 1
Ν	0.256	0.262		0.259	0,259	0.259	0.259	£1	11
0	6.500	6.520		6.511	6.511	6,511	6511	Vesa	CNC-02
Р	5.990	6.010		6.003	6.003	6.003	6.003	(1	4 (
Q	2.820	2.830		2.825	2.825	2,825	2.825	Vesn	GA -01
R	2.495	2.505		2.500	2.500	2.500	2.500	11	11
S	∠.245	2.255		2.250	2.250	2.250	2.250	(1	11
Т	1.120	1.130		1,125	1.125	1.125	1.125	1.1	r t
C	0.540	0.560		G.55Z	0.553	0,557	0.553	(1	(1
٧	0.793	0.803		0.798	0.798	0.798	0.798	(1	(l
W	R.240	R.260		0.250	0.250	0.250	0.250	R-6	(cf.
Х	0.040	0.060		0.050	0,050	0.050	0.050	Vern	GA-01
Υ	0.100	0.120		0.110	0.110	0.110	0.110	(1	. (
AA	R1.125	R1.145		1.135	1,134	1.135	1.135	Dial	HBASZ
AB	R.490	R.510		0.500	0,500	0.500	0.500	R-6	ref.
AC	0.615	0.635		0.635	0.635	0.635	0,635	vein	GA-01
AD	0.240	0.260		0.255	0.254	0.254	0.255	l ₁	(1
AE	1.810	1.830		1.823	1.823	1.823	1.823	11	()
AF	0.240	0.260		0.251	0.251	0.251	0.251	11	t i
AG	0.140	0.160		0.1541	0.153	0.154	0.154	11	t l
AH	0.140	0.160		0.158	0.159	0.159	0.159	t i	11
Ai	0.140	0.160		0.156	0,157	0.156	0.156	1 (11
	Acce	pt/Reject							

Measured by: 片、A	Audited by	217 1
Date: N 01 10	Date:	n/1/1/3

Rev	Date	Change	Revised by	Approved
Α	06.09.26	New Issue	KJ/EC	
В	08.10.07	Dimension H removed	KJ/DD	
С	08.11.28	Dimension 'M' revised	KJ/EC	W

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY



D	art	A	ero	sp	ac	e	Ltd	
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W/O:		WORK ORDEI	RCHANGES	· · · · · - · ·	· · · · · · · · · · · · · · · · · · ·	•		, QC)
DATE STEP		PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
4.				1				
-								

Part No:	· · · · · · · · · · · · · · · · · · ·	PAR #:	Fault Category:		NCR: Yes No DQA:	Date:
•	Resolution:		Disposition:	• .	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
	STEP	Description of NC		Corrective Action Section B	Verification	Approval	Annuaval		
DATE		Section A	Initial Action Description Chief Eng Chief Eng		Section C	Approval Chief Eng	Approval QC Inspector		
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